

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000492**Date Inspected:** 20-Sep-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 200**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Changxing Island**CWI Name:** Lujian Ping**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** 114 A,B,D&E,89**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Larry Viars was present to observe the Ultrasonic Testing (UT) of #114 Mock-up. Observations of Magnetic Particle testing (MT) and Visual Testing (VT) of Mock-up #89 and #114 were monitored as well, for the San Francisco Oakland bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Caltrans QA Inspector observed ZPMC QC performing UT on Mock-up #114 Skin B Plate lower section Complete Joint Penetration (CJP). Caltrans QA witnessed MT, VT, and welding of 114 Skin A,D and E of Mock-up #114.00. MT was performed on Mock-up 89. ZPMC QA inspector Mr. Li Xiu Yong stated, the weld number for Mock-up 89.00 was MUB MA21.

Caltrans QA Inspector observed ZPMC QC nondestructive technician, Ms. E Shuiqin performed Ultrasonic Testing on Mock-up 114.00 Skin B lower section. Caltrans QA observed Ms. Shuiqin perform straight beam and 45 degree shear wave testing of the weld joint from face C. It was reported to the QA by ZPMC QA Mr. Xu Jun that #114 Skin plate B SA102 had been previously heat straightened. At the conclusion of testing Ms. E Shuiqin reported the weld to be acceptable to AWS D1.5 2002 requirements. Magnetic Particle Testing was performed prior to Caltrans QA arriving onsite on 114 Skin D MA113 stiffener Partial Joint Penetration (PJP) tack welds. MT of #89.00 1236 to SA 13 weld # MUB MA21 was performed prior to Caltrans QA inspector arrival onsite. Both MT tests were witnessed by Mr. Steve Lawton with American Bridge. Caltrans QA observed ZPMC QC technician Mr. Cai Xin Xin perform MT of #114.00 Skin Plate E MA108 PJP tack welds and Skin D MA113 weld #7 root pass. ZPMC QC Cai Xin Xin performed MT on excavation areas of #114.00 MA101 stiffeners 1006 and 1009 found both to be acceptable. ZPMC QC technician Mr. Lujian Ping visually inspected tack welds of CD corner internal plate A119. Mr. Ping reported the welds to be acceptable.

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The Caltrans QA Inspector performed VT and MT examinations of the stiffener welds of #114.00 D and E and #89.00 weld MUB MA21. QA Viars monitored the Ultrasonic Inspection of #114.00 Skin B lower section. Inspector observed that testing and welding appeared to be in general conformance with AWS D1.5 2002 requirements. See MT report TL6028 generated on this date for further information.

Summary of Conversations:

As identified within the contents of this report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Viars,Larry	Quality Assurance Inspector
Reviewed By:	Cuellar,Robert	QA Reviewer
